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K6A 1K7
Canada

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D350-636-017
Job Sheet 201095



Part No: D350-636-017

Job Qty: 1 pcs

Part Name: Skidtube LH, Run-on Landing, DART (Apical) Tri-Bag/Air Cruisers Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/25/19

Job Tracking No:

Due Date: 10/11/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG d4168-043 rev.c IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B 11.04.14 ecn11-553 DD verf:EC
IPP Rev:C 11.10.18 as per NCR 11-906 DD verf:EC IPP Rev:D 11.04.16 AS PER ECN 12-542 DD verf:EC
IPP REV:E 13.08.28 PER ECN13-594 DD VERF:JLM IPP REV:F 18.11.12 AS PER DWG REV.C DD
VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	10/11/19		0.00	4.65	Skidtubes - 1		AD
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 10	1 pcs	10/11/19		0.00	0.00	QC 10 - 10		DAS OCT 08 2019 68 8-03
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
130	QC 5	1 pcs	10/11/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		

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					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS OCT 08 2019 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					140 Handfinish - 1-1 Chemical-B4B	1 pcs
Handfinish - 1 - 2 - B4B						
Handfinish - 1 - 3 - B4B						
Handfinish - 1 - 4 - B4B						
Handfinish - 1 - 5 - B4B						
Handfinish - 1 - 6 - B4B						
Handfinish - 1 - 7 - B4B						
Handfinish - 1 - 8 - B4B						
Handfinish - 1 - 9 - B4B						
Handfinish - 1 - 10 - B4B						
Handfinish - 1 - 11 - B4B						
Handfinish - 1 - 12 - B4B						
Handfinish - 1 - 13 - B4B						
Handfinish - 1 - 14 - B4B						
Handfinish - 1 - 15 - B4B						
Handfinish - 1 - 16 - B4B						
Handfinish - 1 - 17 - B4B						
Handfinish - 1 - 18 - B4B						
Handfinish - 1 - 19 - B4B						
Handfinish - 1 - 20 - B4B						
Handfinish - 1 - 21 - B4B						
Handfinish - 1 - 22 - B4B						
150 QC 7	1 pcs	10/11/19	0.00 0.00	QC 7 - 10		
				QC 7 - 13		
				QC 7 - 14		
				QC 7 - 15		
				QC 7 - 17		
				QC 7 - 18	BE	
				QC 7 - 19		
				QC 7 - 2		
				QC 7 - 28		
				QC 7 - 3		
				QC 7 - 30		
				QC 7 - 34		
				QC 7 - 36		

				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
160 Skidtubes - 2 - B4B	1 pcs	10/11/19	0.00 4.65	Skidtubes - 1 - B4B	DO
			1.37 TF	Skidtubes - 2 - B4B	
			DO 2.44	Skidtubes - 3 - B4B	
			562 110	Skidtubes - 4 - B4B	TF
			150 110	Skidtubes - 5 - B4B	BE
			2431	Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
170 QC 10	1 pcs	10/11/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190 Handfinish - 2-1 Pressure-B4B	1 pcs	10/11/19	0.00 0.33	Handfinish - 2 - 1 - B4B	BEB 19-10-10
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	

200 Spray Paint - 2 - B4B	1 pcs	10/11/19	0.00 0.79	Handfinish - 2 - 4 - B4B	
				Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	0.00 19-10-13
				Spray Paint - 3 - B4B	
210 QC 14	1 pcs	10/11/19	0.00 0.00	Spray Paint - 4 - B4B	
				QC 14 - 15	ML 19-10-15
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
230 Handfinish - 4-1-Assembly-B4B	1 pcs	10/11/19	0.00 0.88	Handfinish - 4 - 1 - B4B	ML 19-10-15
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
240 QC 5	1 pcs	10/11/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	

DAS
15
9-89

				QC 5 - 30		
				QC 5 - 40	OCT 16 2019	DAS 40
				QC 5 - 61		9-89
				QC 5 - 81		
250	Packaging 1-1 - Pick Kit - B4B	1	10/11/19	0.00 0.00	Packaging 1 - 1 - B4B	
	pcs				Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	PC
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36	
260	QC 4	1	10/11/19	0.00 0.00	QC 4 - 28	
	pcs				QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
					QC 4 - 75	
						DAS 78
						9-89
270	Packaging 3-1 - Stock - B4B	1	10/11/19	0.00 0.00	Packaging 3 - 1 - B4B	OCT 22 2019
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
				Plex 9/25/19 9:41 AM Dart.Renwick.Jennifer		

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	DAS 78 9-89
				Packaging 3 - 26 - B4B	OCT 22 2019
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1	10/11/19	0.00 0.00	DC - 1 - B4B	DAS 21 9-39
	pcs			DC - 2 - B4B	OCT 22 2019
280 QC 21 - FG	1	10/11/19	0.00 0.00	QC 21 - FG - 21	DAS 21 9-39
	pcs			QC 21 - FG - 70	OCT 22 2019
				QC 21 - SA - 53	

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
 Descriptions: D4168-3 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes using drill Jig DT8150 & DT8864A for first side only DT8864B for second side. 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting 6-Drill pilot holes for wearplates as per Dwg D4168 using DT9678. Locating from 66.54" holes. 7-Open up holes of Detail S to 0.297" (total of 2 holes per side) +.201"(total of 1 per side DT9616) 8-Weld D2744 Cap as per Dwg D4168 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch:

- 139011 9-Grind welds flush as per Dwg D4168
 120 - QC10- Inspect visual per QSI004- ground welds
 130 - QC5- Inspect part completeness to step on W/O
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - QC7-Inspect Chemical Conversion Coat

160 - 1-Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168. 2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D4168. 3- Open float hole using uni-bit to 0.500" (4 per side) 4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D4168 (welding instructions on sheet 8) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch:

exp. date: ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 139011 9- At section AJ-AJ drill out x-bolt spacer to 0.404" 10-Grind welds flus
 170 - QC10- Inspect visual per QSI004- ground welds

180 - QC5- Inspect part completeness to step on W/O

190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings), Pressure Wash per QSI005 4.3, Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - (Spray Paint / NDT Room), Spray Painting per QSI005 4.2 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5 200399 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5 213125

210 - QC14- Inspect Spray Paint Inspect for foreign object per QSI 024

230 - (Assemble as per dwg): 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting D3488-3, wearshoes and ground handling hardware as per dwg D4168 SIKA FLEX 241 BATCH: 5200627 EXP DATE: 20-7-25 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 14139043 5-Coat all exposed fasteners with "LPS Procyon" batch: 5133690

240 - QC5- Inspect part completeness to step on W/O

250 - Pick Kit

260 - QC4- 100% Inspect kits for completeness *****ensure antiseize is on AN8C21A bolts*****

270 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPPD350-636-017 Location : FG071

275 - Document Control Photocopy blue file and type labels per PPP D350-636-017 CHG 006

280 - QC21- Final Inspection - Work Order Release

Job BOM

012448

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 pcs (1 ea)	110-Skidtubes - 1	5216547
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5192776
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 2 - B4B	5219546
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 2 - B4B	5194932
D3490-1	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5210529
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5192155
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5186091
AN3C36A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	FML1380092
AN3C37A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	
AN3C42A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5167183
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5216233
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5217983
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5206359
D3488-3	Blade Fitting, LH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5184950
D3490-5	Cross Bolt Spacer	4 pcs (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5132494
D3492-1	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5204549
D3492-5	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5191167
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5184192
D3873-1	Bushing	7 pcs (7 ea)	230-Handfinish - 4-1-Assembly-B4B	5215611
D4154-041	Wearplate Assembly	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5195471
D4170-1	Bushing	4 pcs (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5175928
D4171-1	Bushing	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5180796
MS21043-3	Nut	5 Ea (5 ea)	230-Handfinish - 4-1-Assembly-B4B	5099569
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5216287
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5192757
NAS1149C0332R	Washer (AN960C10L)	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5218151
NAS1149C0363R	Washer (AN960C10)	9 Ea (9 ea)	230-Handfinish - 4-1-Assembly-B4B	5135100
NAS1149C0832R	Washer (AN960C816L)	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	50760173
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5214921
NAS1611-005	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5194425
NAS1611-010	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5057600
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5184404
D3741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5210551
D3490-1	Washer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5194486
MS21043-3	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5215512
NAS1149C0832R	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5166718

AN3C42A

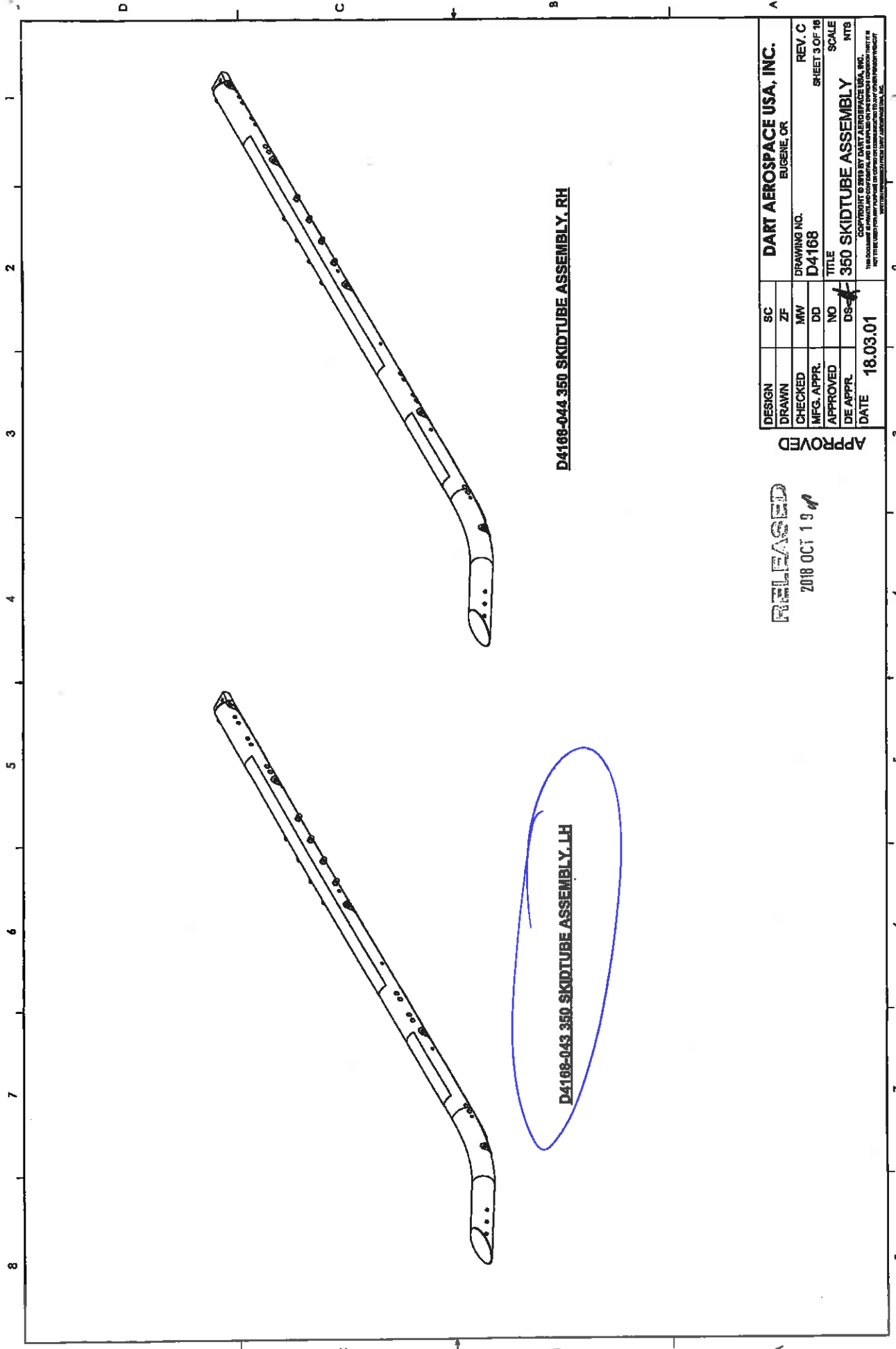
IX

5108570

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-LH	1	12	0
	D2744	1	34	0
160-Skidtubes - 2 - B4B	D2739	1	4	0
	D2743	8	369	0
	D3490-1	4	190	0
230-Handfinish - 4-1-Assembly-B4B	ALS4-1032-225	4	1,716	0
	AN3C34A	1	32	0
	AN3C36A	4	195	0
	AN3C37A	1	76	0
	AN3C42A	1	68	0
	AN3C6A	4	75	0
	AN6C44A	4	90	0
	AN8C35A	1	9	0
	D2745	8	56	0
	D3488-3	1	27	0
	D3490-5	4	147	0
	D3492-1	8	52	0
	D3492-5	8	212	0
	D3631-1	8	208	0
	D3873-1	7	137	0
	D4154-041	1	6	0
	D4170-1	4	121	0
	D4171-1	1	20	0
	MS21043-3	5	546	0
	MS21043-6	4	124	0
	MS21083C8	1	125	0
	NAS1149C0332R	4	2,561	0
	NAS1149C0363R	9	540	0
	NAS1149C0832R	1	262	0
	NAS1515H3L	4	223	0
	NAS1611-005	8	374	0
	NAS1611-010	8	91	0
250-Packaging 1-1 - Pick Kit - B4B	AN8C21A	2	67	0
	D2741	1	58	0
	D3493-1	2	23	0
	MS21083C8	2	125	0
	NAS1149D0863J	2	311	0
Part Specifications				
Specifications could not be found.				

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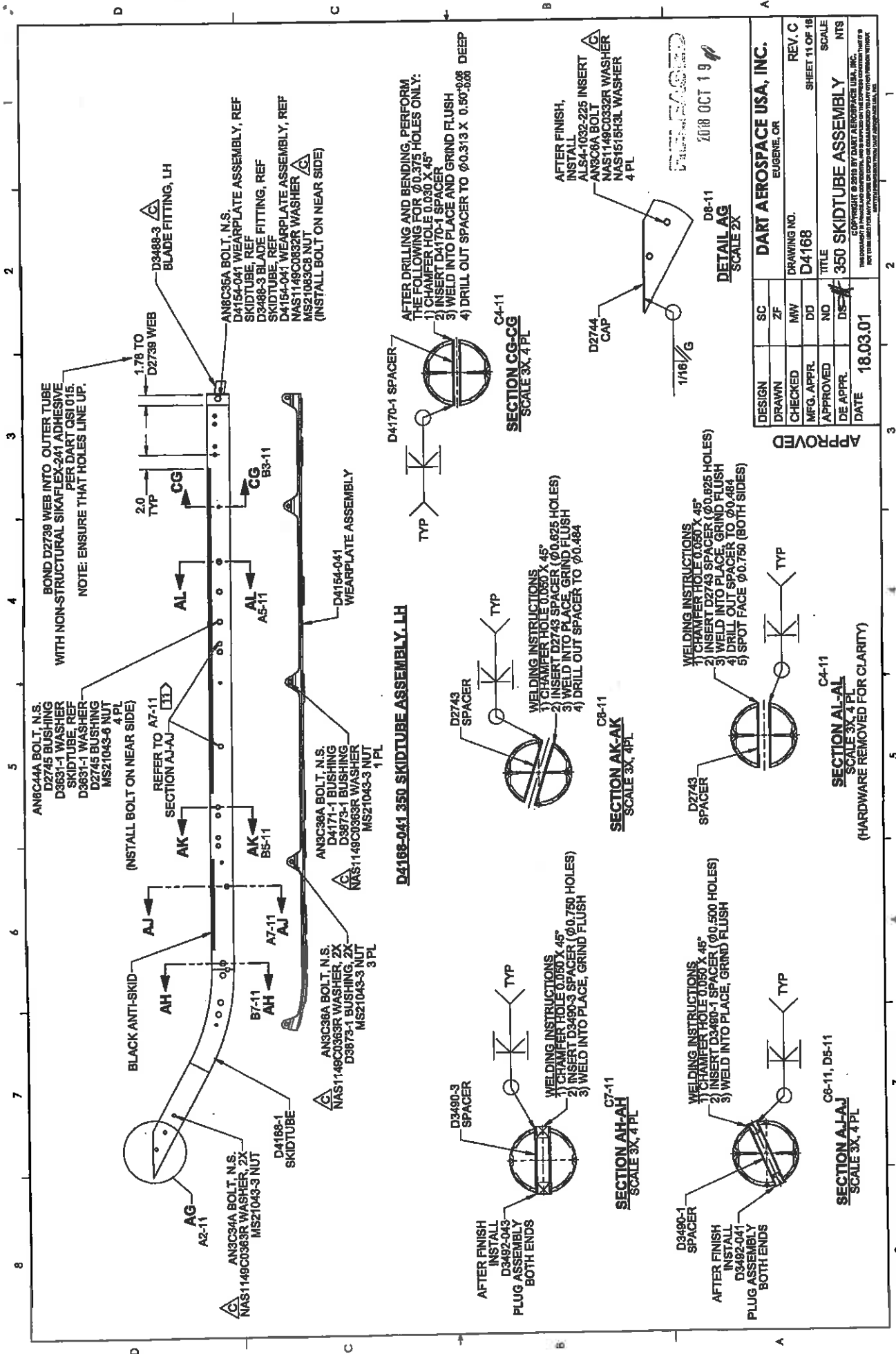
D4168-044 350 SKIDTUBE ASSEMBLY, RH

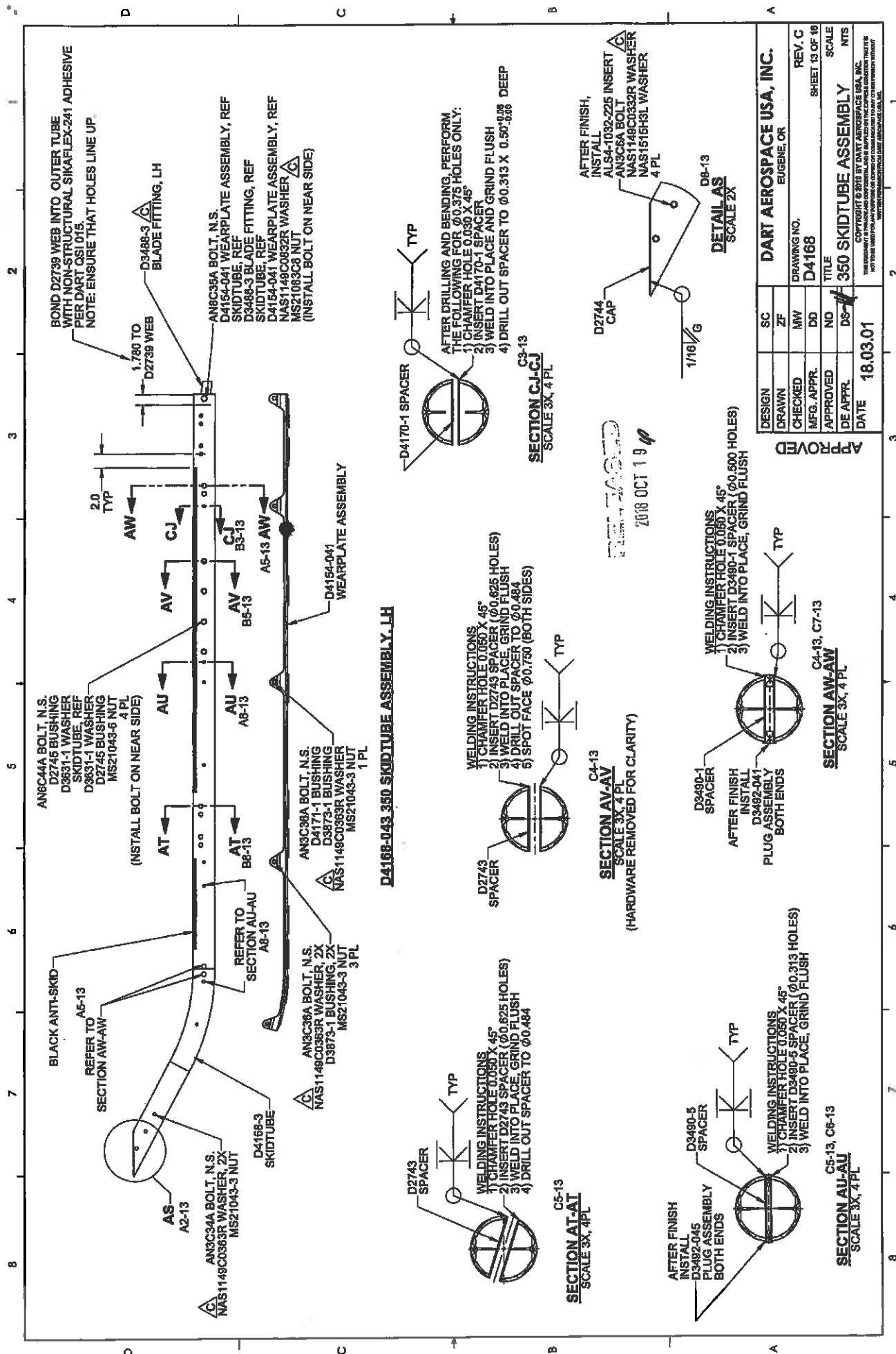
D4168-043 350 SKIDTUBE ASSEMBLY, LH

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MV	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 3 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE 18.03.01		COPYRIGHT © 2003 BY DART AEROSPACE USA, INC.	
		THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE FOR REPRODUCTION IN WHOLE OR IN PART WITHOUT LIMITATION.	

RELEASED
2018 OCT 19

APPROVED





Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐				DEPARTMENT/PROCESS Skid-tube ☐ Eng. (Non-AW) ☐ Machining ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				MRB (QSI042)													
Date: _____		Sequence #: _____		QTY Affected: _____																			
Description Work Order Deviation						Disposition																	
Completed By						Lead hand / Supervisor																	
												QC / QA Coordinator											
												Root Cause						FAULT CATEGORY					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐						Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐						Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐						Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
Other/Details:																							

7.0 PARTS LIST

D350-636-015/-016/-017/-018 SKIDTUBES AT CHG 006 AND SUBSEQUENT
D350-636-023/-024 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
	X							D350-636-015	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
		X						D350-636-016	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
			X					D350-636-017	SKIDTUBE INSTALLATION, LH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
				X				D350-636-018	SKIDTUBE INSTALLATION, RH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
					X			D350-636-023	SKIDTUBE INSTALLATION, LH, STD COMPATIBLE W/TRAINING WEARPLATE
						X		D350-636-024	SKIDTUBE INSTALLATION, RH, STD COMPATIBLE W/TRAINING WEARPLATE
							X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1							D4168-041	SKIDTUBE ASSEMBLY, LH
1		1						D4168-042	SKIDTUBE ASSEMBLY, RH
1			1					D4168-043	SKIDTUBE ASSEMBLY, LH
1				1				D4168-044	SKIDTUBE ASSEMBLY, RH
1					1			D4168-051	SKIDTUBE ASSEMBLY, LH
1						1		D4168-052	SKIDTUBE ASSEMBLY, RH
*1	1							D4168-1	SKIDTUBE WELDMENT, LH
*1		1						D4168-2	SKIDTUBE WELDMENT, RH
*1			1					D4168-3	SKIDTUBE WELDMENT, LH
*1				1				D4168-4	SKIDTUBE WELDMENT, RH
*1					1			D4168-5	SKIDTUBE WELDMENT, LH
*1						1		D4168-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149CO832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
*8	1		1		1			D3488-3	BLADE FITTING, LH
*8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2741	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149CO863J	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149CO332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER

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Revision: K
Date: 18.04.04

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
*90	1	1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	1	1	AN3C37A	BOLT ²
91C	1	1	1	1			1	AN3C42A	BOLT ³
*92	7	7	7	7	7	7	8	NAS1149CO363R	WASHER
92A			1	1				NAS1149CO363R	WASHER ³
*93	4	4	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	7	7	8	D3873-1	BUSHING
94A			1	1				D3873-1	BUSHING ³
*95	1	1	1	1	1	1	1	D4171-1	BUSHING ⁴
96							4	D4170-3	SPACER
*97	1	1	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	2	2	NAS1149CO363R	WASHER
*99	1	1	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044/-051/-052

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH DART CYLINDRICAL OR TRI-BAG FLOATS

² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART CYLINDRICAL BAG FLOATS

³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

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Revision: **K**
Date: 18.04.04

RELEASED
18.10.23

3RB

PPP

DART
AEROSPACE

Part Number	D350-636-017	Box Part Number	MBX104	Dimension	L x W x H 118.5 X 12 X 6
Description	Skidtube, LH	Other Packaging	MF6812		MF1612
		Logo Decals	D2728-1		

Packaging Instructions and Decal Placement

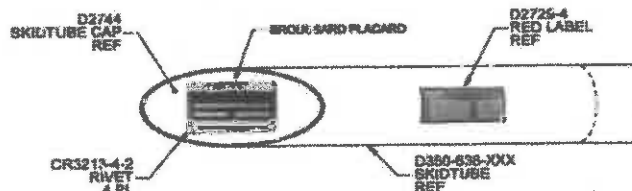
D350-636-017

Apply label D2729-4 & D2728-1 as per drawing below.

Wrap skidtube in plastic. Wrap hardware kit and paperwork in foam and put kit in bore of foam MF6812 (at forward end of skidtube). Glue 2 pieces of MF1612 foam, one at each end of box. Put 3 pieces of MF6812 in bottom of box. Place skidtube in box and place 3 MF6812 to correspond with bottom MF6812. Apply glue on top pieces of foam and close box. Apply Dart tape and strap. Apply D2729-3 label as per instructions in QSI 014.



For skidtubes that are manufactured as a PMA replacement part, a Broussard placard and the D2729-4 label must be installed on the skidtube as per drawing below.



D2729-4

D2729-3

DART		118442 BERTH RD, CANADA K6A 1K7 TEL: 1 613 632-5200	
PART NO	US #5735484 / CA #2222184 / EURO #0828655	CHG	CHG006
P/N	D350-636-017	STC	SH99-7
DESC	Skidtube, LH	STC	SR00646SE
AUT	SXXXXXX		
MODEL	AS350/355		
10 APPROVED 19 88		MADE IN CANADA	

DAS
18
3-92

18/10/23

Revision: *gmd*
Date: 18.10.23

DART AEROSPACE		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200
SKIDTUBE, LH		
P/N: D350-636-017	CHG006	
S/N: SXXXXXX		

Change Record

PAGE 1 OF 1

Part Number: D350-636-017/-018

Description: SKIDTUBE STD LH/RH w/ TRAINING WEARPLATE

[illegible]